

09/9/2457

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Abstract of the Disclosure

In a method of cutting a cloth of the invention, a cloth woven by warps and wefts is cut at 45 to 55 degrees to divide the cloth into a left-to-right cutting bias portion and a right-to-left cutting bias portion as bias cloths. The left-to-right cutting bias portion has a left-to-right stretching direction, and the right-to-left cutting bias portion has a right-to-left stretching direction. Then, the right-to-left cutting bias portion and the left-to-right cutting bias portion are cut into bias front cloths, bias adhesive core pieces, bias adhesive tapes, and bias linings. By crossing the bias core pieces or the like having the different stretching directions and bonding to a stretchable cloth, a stable stretchability and tension can be given to the stretchable cloth.